

Work Order ID 67363

Wednesday, March 16, 2011 12:53:31 PM



Page 1

Item ID:	D119-675-012	Accept		Setup	Start	
Revision ID:						
Item Name:	Heli-Access-Step RH				Stop	
Start Date:	3/16/2011	Start Qty: 4.00		Cust Item ID:		
Required Date:	3/31/2011	Req'd Qty: 4.00		Customer:		
Reference:						

Approvals:	Process Plan:	<i>mf</i>	Date:	<i>11-03-16</i>	Tooling:	Date:		Run	Start	
	QC:		Date:		SPC (Y/N):	Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
N/A	Rev N/A

100		0.00							
	DOCUMENT CONTROL								
DC	Memo	0.00							
Document Control	Photocopy bluefile & type labels per PPP 119-675-012 CHG003								

8 uls/13

ek for a 11/04/26

110	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging									

11/4/26

120	QC4- 100% Inspect kits for completeness	0.00							
QC	Memo	0.00							
Quality Control									

8 uls/13

(74) RH

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Work Order ID 67363

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Item ID: D119-675-012

Accept



Setup Start



Revision ID:

Item Name: Heli-Access-Step RH

Stop



Start Date: 3/16/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 3/31/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D119-675-012 Location: <u>Neu D</u>								
140 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

11/05/13 (4)

CK 11/05/13
ME
11-05-13-

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 67363

Parent Item: D119-675-012

Parent Item Name: Heli-Access-Step RH

Start Date: 3/16/2011

Required Date: 3/31/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:D Removed Manufacturing JLM 05-11-01
IPP Rev:E change to rev.b as per ECN1107 DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3043-042 Step Weldment RH, A119		Manufactured	No			110	Each	0.0000	1	4			
D2182B032 Rubber Cushion		Manufactured	No			110	Each	20.0000	4	16			
<div> <div>Location</div> <div>ST402</div> <div>63469</div> </div> <div> <div>Loc Qty</div> <div>20</div> <div>20</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
D2274 Radius Block		Manufactured	No			110	Each	396.0000	8	32			
<div> <div>Location</div> <div>ST010</div> <div>61361</div> <div>63990</div> <div>65562</div> <div>65757</div> <div>66123</div> </div> <div> <div>Loc Qty</div> <div>396</div> <div>1</div> <div>6</div> <div>16</div> <div>250</div> <div>123</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> <div></div> <div></div> <div></div> </div>													
D2617-3 Bushing		Manufactured	No			110	Each	41.0000	4	116			
<div> <div>Location</div> <div>ST019</div> <div>52651</div> </div> <div> <div>Loc Qty</div> <div>41</div> <div>41</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													

4

67365

4.2640
B66073

675785

11/4/275
B68254

11/5/125

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

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Work Order ID: 67363

Parent Item: D119-675-012

Parent Item Name: Heli-Access-Step RH

Start Date: 3/16/2011

Required Date: 3/31/2011

Start Qty: 4.00

Required Qty: 4.00

D2617-5
Spacer

Manufactured No

110 Each

14.0000

8

32

B67368

Location

Loc Qty

Loc Code

ST019

14

66157

14

110 Each

0.0000

1

D2732-032 Manufactured No

RUBBER CUSHION

D3041-1 Manufactured No

Clamp

110 Each

16.0000

4

16

B67778

Location

Loc Qty

Loc Code

ST463

16

65638

16

110 Each

22.0000

2

D3041-3 Manufactured No

Clamp

Location

Loc Qty

Loc Code

ST463

22

51114

2

65639

20

110 Each

15.0000

4

D3042-1 Manufactured No

Clamp

Location

Loc Qty

Loc Code

ST457

15

48241

15

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Shop Packet Print

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 67363

Parent Item: D119-675-012

Parent Item Name: Heli-Access-Step RH

Start Date: 3/16/2011

Required Date: 3/31/2011

Start Qty: 4.00

Required Qty: 4.00

AN4-11A
Bolt

Purchased No

110 Each

234.0000

4

16

11/4/27

Location

Loc Qty

Loc Code

ST357

234

110382

34

115316

200

AN4-12A
Bolt

Purchased No

110 Each

226.0000

8

32

Location

Loc Qty

Loc Code

ST357

226

112314

26

115371

40

115422

160

AN4-15A
Bolt

Purchased No

110 Each

310.0000

4

16

Location

Loc Qty

Loc Code

ST308

296

116786

296

ST358

14

114784

9

115108

5

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
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Work Order ID: 67363

Parent Item: D119-675-012

Parent Item Name: Heli-Access-Step RH

Start Date: 3/16/2011

Required Date: 3/31/2011

Start Qty: 4.00

Required Qty: 4.00

AN960JD416 NAS1149D0463J Purchased

No

110

Each

30.0000

12

48



Washer



M117065

Location

Loc Qty

Loc Code

ST300

24

113288

24

ST356

6

115622

6

MS21042L4

Purchased

No

110

Each

4,219.000

12

48



Nut



114668

Location

Loc Qty

Loc Code

ST300

4219

1123143

2

115589

10

115621

20

116188

2187

116823

2000

78

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____

Resolution: _____

Fault Category: _____

Disposition: _____

NCR:

DATE	STEP	Description of NC Section A	Corrective Action		Sign & Date	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		

NOTE: Date & initial all entries

4.0 WEIGHT AND BALANCE:

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D119-675-011	11.5 lb	- 32.4 in	- 373 in-lb	121.3 in	1395 in-lb
HELI-ACCESS-STEP™, LH	5.2 kg	- 1.28 m	- 6.7 m-kG	3.08 m	16.0 m-kG
D119-675-012	11.5 lb	+32.4 in	+373 in-lb	121.3 in	1395 in-lb
HELI-ACCESS-STEP™, RH	5.2 kg	+1.28 m	+6.7 m-kG	3.08 m	16.0 m-kG

5.0 PARTS LIST:

Qty -011	Qty -012	Part Number	Description
X		D119-675-011	HELI-ACCESS-STEP™, LH
	X	D119-675-012	HELI-ACCESS-STEP™, RH
4	4	D2182B032	RUBBER CUSHION
8	8	D2274	RADIUS BLOCK
4	4	D2617-3	BUSHING
8	8	D2617-5	BUSHING
4	4	D2732-032	RUBBER CUSHION
4	4	D3041-1	CLAMP
2	2	D3041-3	CLAMP
4	4	D3042-1	CLAMP
1		D3043-041	STEP WELDMENT LH
	1	D3043-042	STEP WELDMENT RH
4	4	AN4-15A	BOLT
4	4	AN4-11A	BOLT
8	8	AN4-12A	BOLT
12	12	AN960JD416	WASHER
12	12	MS21042L4	NUT (OR MS21042-4)

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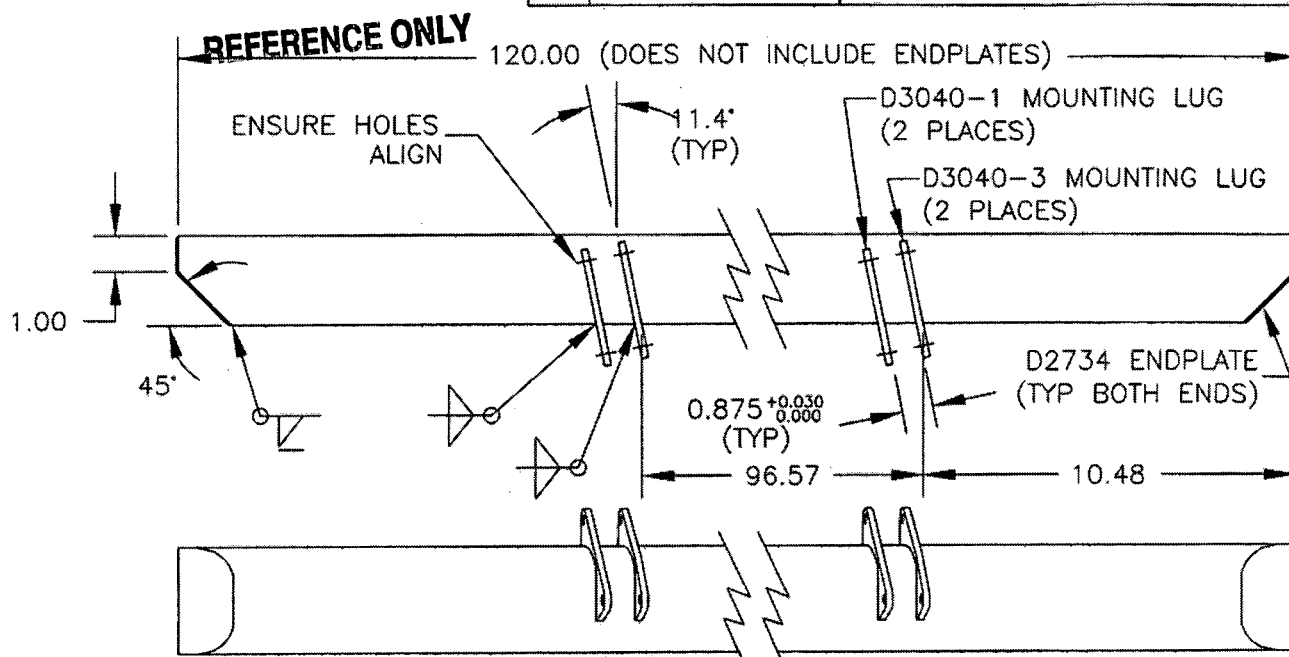
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Revision: B

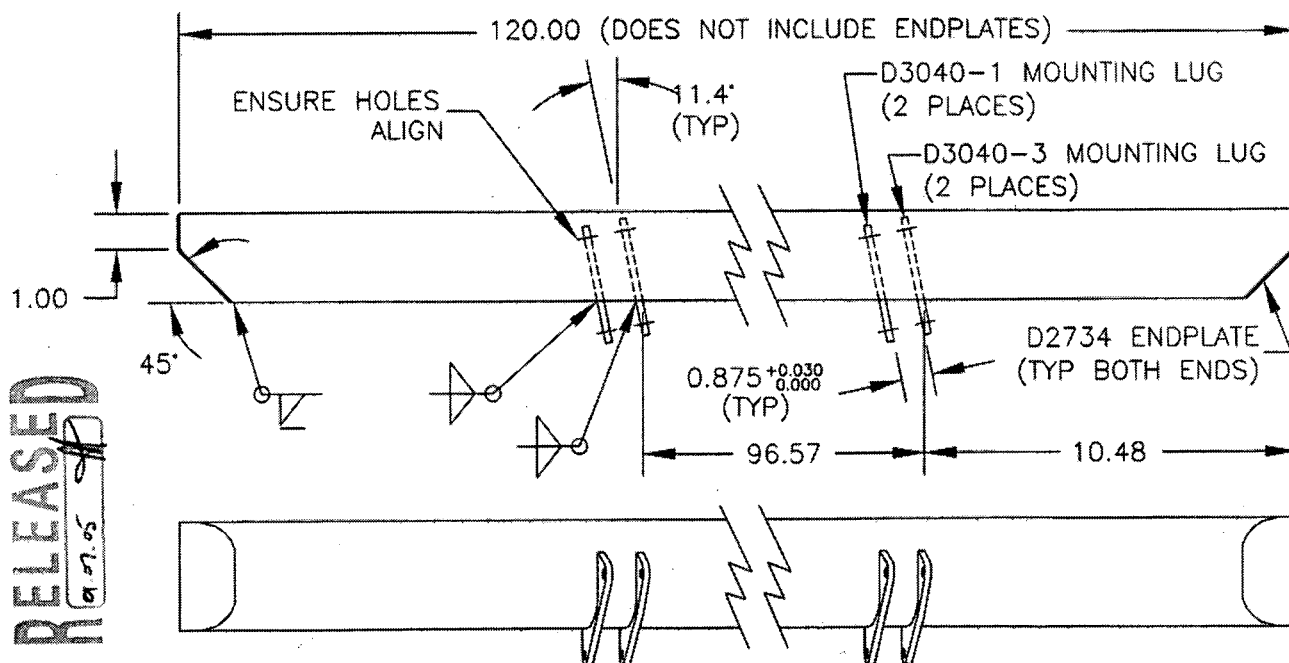
Date: 07.10.23



DESIGN CP	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED #	APPROVED #	DRAWING NO. D3043	REV. A SHEET 2 OF 2
DATE 01.06.28		TITLE A119 STEP WELDMENT	SCALE 1:5
A	01.06.28	NEW ISSUE	



VIEW A-A: D3043-041 LH STEP WELDMENT



VIEW A-A: D3043-042 RH STEP WELDMENT

RELEASED
9/27/05

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